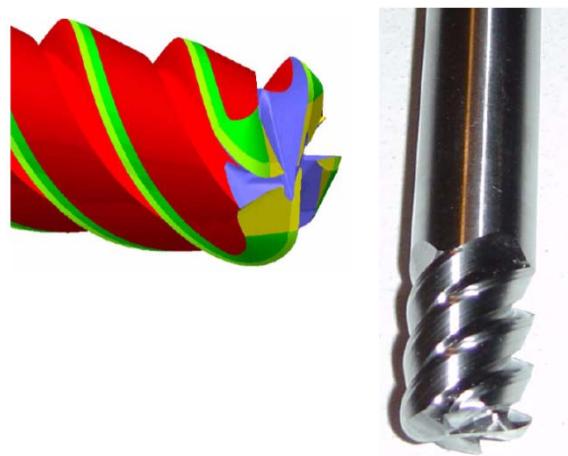


Endmill Ø18 Z4

A01-010

Cylindrical endmills with radius are standard tools used in High speed milling, die molding milling and milling applications in the aircraft industry. The benefits of the corner radius are an improvement of the surface quality of milled parts, a damage reduction of the corner of the endmill, a reduction of stressintensity effects of milled parts under tensile stresses.



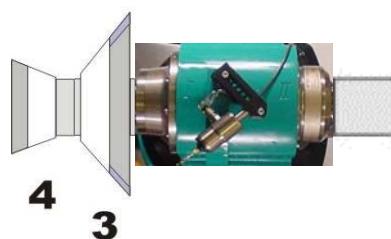
1. Cycletime for

Tool specifications							
Material	Diameter 18 mm, Z 4, Length of cutting edge 35 mm, Helix angle 30°						
Operations							
Feed [mm/Min]	1500	140	100	140	120	100	120
Power [kW]		2	2	1	1	1	1
Cutting feed [m/s]		18	18	20	20	20	20
Used wheels							
Grinding time [s]	31	99	63	394	442	48	42
Total cycle time	19 Min 21						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

3	12V9 Ø125 D64
4	11V9 Ø75 D64



3. Machine and Software Requirements

Machines: 4 axes CNC grinders : Aries ENP4
 Control: Fanuc 35i
 Coolant: Synthetic Oil, pressure 6 bar
 Software: Menuguided ISO-programming with macroexecuter

responsible engineer: KCM, 7.01.09

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

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